Qty:

2 Um:

Each

User

Friday, 25/07/2008 4:20:52 PM

Julie Lecoca

Process Sheet

Drawing Name

Part Number

Due Date

Description:

304/316 Sheet .063

0.4431 sf(s)

Drawing Number

Project Number

Drawing Revision Material

: BRACKET

: D21951

: N/A

: C

: D2195 REV C

: 20/08/2008

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number

: 40763

Estimate Number

: 13506

P.O. Number

This Issue Prsht Rev.

: 25/07/2008 : NC

: // First Issue

Previous Run

Written By

Comment

Checked & Approved By

08-07-24 new issue

: SMALL /MED FAB

ec_verified by:dd

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

M304S16GA

Comment: Qty.: 0.2216 sf(s)/Unit Total:

304 SS Sheet 0.063" thick

batch: 168 734

2.0

Comment: FLOW WATER JET

1-Cut as per Dwg D2195

Dwg Rev:

18-8-8 B

Prog Rev:__

2-Deburr if necessary

188-8-21

3.0

B8-8-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

SECOND CHECK

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: NC BRAKE

Bend as per dwg D2195

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector	
		3						
Part No	•	PAR #: Fault Category: NO	R. Ves	No DO	Δ.	Date	1	

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
DATE		Description of NC		Varification	Ammanual	A						
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
				*								
						!						

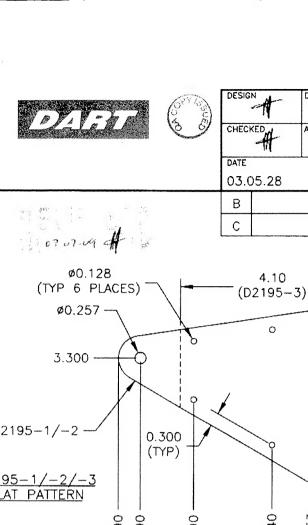
NOTE: Date & initial all entries

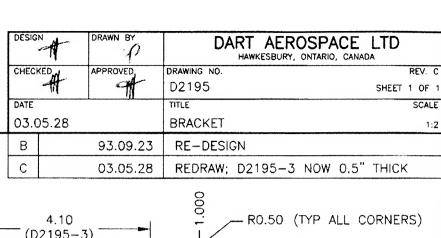
Friday, 25/07/2008 4:20:52 PM User: Julie Lecocq **Process Sheet** Drawing Name: BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 40763 Part Number: D21951 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 7.0 PACKAGING RESOURCE #1 11 08/08/06/4, W 08/08/06/4, Identify wiith Dart part # using a fine point permanent marker and Stock Location & 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHA	NGE	I	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
`		X At								
	13	- + -								
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Part No	:	PAR#:	Fault Cate	gory:	NCR:	Yes N	o DQ	A :	Date:	
	- 4								Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NCR)				
DATE	STEP	Description of NC Corrective Action Section				Verification			Approval	Approval
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector	
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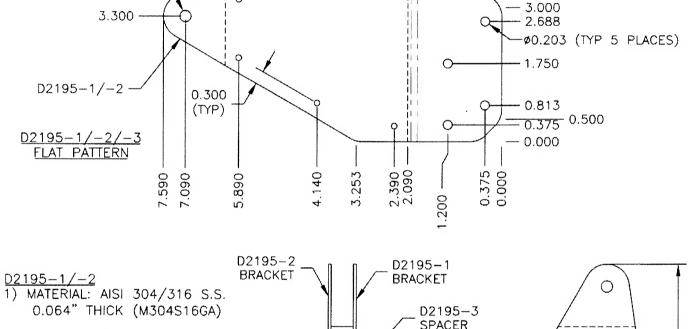
NOTE: Date & initial all entries





- 4.000

3.625



D2195 - 32) MATERIAL: 5052H32 (QQ-A-250/8) 0.500" THICK OR 4x0.125 THICK 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 D2195 BRACKET (ASSEMBLY): 4) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

GENERAL NOTES:

5) ALL DIMENSIONS ARE IN **INCHES**

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) BREAK ALL SHARP EDGES 0.005 TO 0.015

SPACER **(**) 0 MS20470AD4-14 5.70 RIVET (6 PLACES) 0 SHOP COPY 0 RETURN TO ENGINEERING UNCONTROLLED COP' 2.00 -SUBJECT TO AMENDMENT - R0.063 WITHOUT NOTICE

D2195 BRACKET

(ASSEMBLY)

WORK ORDER

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DARTAEROSPACE LTD	Work Order:	40763
Description: BRACKET	Part Number:	D2195-1
Inspection Dwg: D 3/9(- Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
861. \$	100 200. +	.130	ykr			
\$.128	4.665001	,⊃65	*			
Ø ,257	100-001	.259	*			
.375	-4010	7.52	*			
,813	4 - 00	, 816	t			
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7.688	4/_ 010	693. G	X			
3.625	4- 1010	3,631	×			
4.000	1/ 40	4,007	×			
.375	4010	.375	*			
1.300	1/2 -010	1 199	*			
2,390	1/2 1010	2,390	₩			
4.140	1/010	4.143	a			
5,890	4 010	5,894	ধ			
7.090	+1010	7,092	X		:	
7.590	4- 1010	7.593	4			
.663	4010	,059	*			
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		- 8 -				
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					61	

						<u> </u>
Measured by:	IR	Audited by:		Prototype Approval:	N	
Date:	8-8-91	Date:	16/30/30	Date:		9

Rev	Date	Change	Revised by	Approved
Δ		New Issue	KJ/JLM	4

